

Date: 6/23/2006 8:54AM
 User: Linda Lacelle

PROCESS SHEET

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD TUBE ASSEMBLY
Job No.	: 27676	Part No.	: D3391021
Estimate No.	: 10467	Drawing No.	: D3391 REV E
P.O. No.	: N/A	Drawing Rev.	: E
First Issue	: 1/1	Project No.	: N/A
Prsht Rev.	: NC	Material	: N/A
This Issue	: 6/23/2006	Due Date	: 7/30/2006
Prev. Run	: 27675	QTY:	: 1
SO No.	: N/A	Type	: MACHINED PARTS

Written by:

Checked & Approved by:

Comment :

Est. A 05.09.13 New issue KJ/JLM
 Est. B 06.02.10 Dwg rev.D ecn 773 EC
 Est. C 06.05.02 Added inspections EC

Job Number:



Seq. No.	Machine or Operation	Description
1.0	D6013047	SKIDTUBE MAT'L
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) SKIDTUBE MAT'L Pick: Qty Part Number Description Batch 1 D6013-047 Extrusion B23935 DP06-6-23	
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment: LANDING GEAR RESOURCE 1 Cut extrusion to 46.52 +0.010 -0.020 7/26/06/06/23	
3.0	BENDING	BENDING MACHINE
	Comment: Nc bender Bend as per Dwg D3391 Using Bend Prog 3391021 DP06-6-23	
4.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP 7/26/06-06-23	
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA590 Rev. AA & Dwg D3391 Rev. E Identify as D3391-1 2-Deburr 7/26/06/07/10	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Number:



Seq. No.	Machine or Operation	Description
6.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
7.0	QC8	INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK
	Comment: SECOND CHECK	
8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment: LANDING GEAR RESOURCE 1	
	1-Drill and c'sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A")	<i>pm '06-08-280</i>
	2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step	<i>pm '06-08-280</i>
	3-Open tow cap holes to .208" as per Dwg D3391	<i>pm '06-08-280</i>
	4-Open Tow Ring hole to .640" as per Dwg D3391	<i>pm '06-08-280</i>
	5-Drill wearplate holes as per Dwg D3391 Using Dt8217 & DT8878	<i>pm '06-08-300</i>
	6-Deburr	<i>pm '06-08-300</i>
9.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	<i>DP 6-8-30</i>
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	<i>06/10/11</i> ①
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<i>yl</i> <i>07/02/21x1</i>
12.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	<i>M.R/a.m.</i> ① <i>07/02/24</i>
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<i>SAD</i> <i>07/02/24</i>
14.0	NAS1330C3KB166	INSERT

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. No.	Machine or Operation	Description
	Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s) Rivnut Pick: Qty Part Number Description Batch 14 NAS1330C3KB166 Insert	B 100732 a.m 07/02/24 124
15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		m.a/a.m 07/02/24
	Comment: HAND FINISHING RESOURCE #1 Install Inserts as per Dwg	
16.0	QC5	INSPECT WORK TO CURRENT STEP
		For 260 Ex 07/02/24
	Comment: INSPECT WORK TO CURRENT STEP D3401041	
17.0	Tow Cap Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Tow Cap Assembly Pick: Qty Part Number Description Batch 1 D3401-041 Tow Cap	B 29214
18.0	AN3C4A	BOLT
	Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Bolt Pick: Qty Part Number Description Batch 4 AN3C4A Bolt	M 101390
19.0	NAS1515H3L	WASHER
	Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Washer Pick: Qty Part Number Description Batch 4 NAS1515H3L Washer	M 103481
20.0	AN960C10L	washer
	Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) washer	M 103344 a.m 07/02/24 240
21.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Install tow Cap as per Dwg D3391 Identify as D3391-021	a.m 07/02/24 240
22.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP Inspect thread of each insert using DT8821	07/02/24

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Seq. No.	Machine or Operation	Description
23.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>N/A u</i>	
24.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21 <i>OK 12/27</i>	

Job Completion



U 07-2-26

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